

# Work Order ID 85781

June-15-12 10:45:10 AM

ASAP

\*85781\*

Page 1

Item ID: D2365

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Wearplate

Stop \*NS2\*

Start Date: 15/06/2012 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/15 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D2365 Rev C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2365 Dwg Rev: C Prog Rev: C 2-

Deburr if necessary

6061, 063"

B12-6-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

B12-6-17

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

8/2/06/18

conts  
(133)

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**\*85781\***

Page 2

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Accept

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Setup Start **\*NS1\***

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Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

35 6 12-6-18

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

8 12/06/14

35

150

Small Fab

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

Install Insert as per Dwg D2365

35 8 12-06-19

# Work Order ID 85781

**\*85781\***

Page 3

June-15-12 10:45:10 AM

Item ID: D2365

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 15/06/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

87/06/19

count  
(435)

170

Identify as per dwg & Stock Location: 008

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

35

12/06/2012

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/06/2012

12-06-20

# Picklist Print

June-15-12 10:45:14 AM

Page 1

Work Order ID: 85781

\*85781\*

Parent Item: D2365

\*D2365\*

Parent Item Name: Wearplate

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM  
(IPP Rev:B Now On Waterjet 08-04-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

FE-832-EF

Purchased

No

100

Each

0.0000

2

48

35

\*FF-832-FF\*

\* 82502  
85727

\*\*

43

FF 12-06-19

PEM Insert

M6061T6S.063

Purchased

No

150

sf

551.1868

0.0047

0.118737

\*\*

135

B12-6-17

\*M6061T6S 063\*

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

551.1868320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

9.94

120218

19.32

120866

66.1026316

121805

339.064632

119802

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/>            Other <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

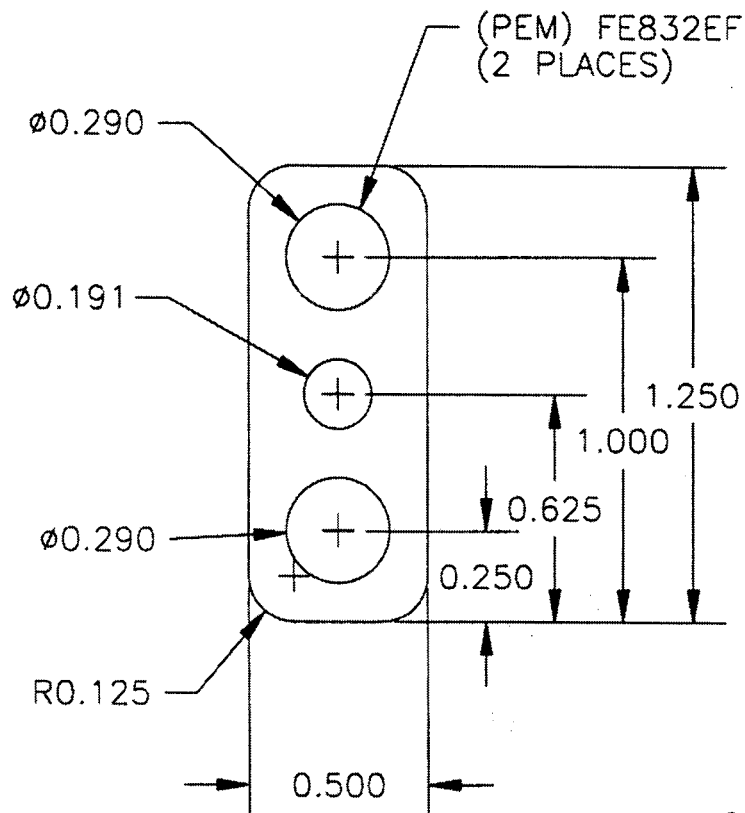
FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other _____ _____ _____





DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED Bw	APPROVED [Signature]	D2365	SHEET 1 OF 1
DATE 95:01:20	TITLE WEAR PLATE		SCALE 2:1
C	95:03:06	0.191 WAS 0.197	

RELEASED  
17/04/22 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85181 M.C.S.  
12/06/10

6061-T6 (00-A-250/11) 0.063 THICK } # 00.09.26  
ACID ETCH & ALUDINE PER QSI D05 4.1-1 } #  
INSTALL FE832EF (2 PLS) AFTER ALUDINE }  
~~AKI 304/346 SS~~

MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK } # 00.03.07  
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES } #